

Work Order ID 50181

July 10, 2009 8:56:26 AM



Page 1

Item ID: D2221
Revision ID: H
Item Name: 350 Basket Base

Accept



Setup Start



Stop



Start Date: 7/14/09 Start Qty: 1.00
Required Date: 7/24/09 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2221	Rev H
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100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221□2-
remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per
dwg D2221□3- tack weld mesh on basket as per dwg D2221□ A/R ER316
S.S. Rod Batch: M108160

PD 09.07.16

110

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PC 09.07.20

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

=> S 09.07.20

④

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Item ID: D2221

Accept



Setup Start



Revision ID: H

Stop



Item Name: 350 Basket Base

Start Date: 7/14/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/24/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

PRESSURE WASH

UMO 09/07/20 (XN)

Memo M110148.

0.00

1- Plug holes prior to ☐ 2- ☐ 1ST COAT: ☐ START

TIME: 7:45 ☐ OVEN TEMPERATURE:

460° ☐ FINISH TIME:

7:15 ☐ ***** 2nd coat if

necessary ***** ☐ 2ND COAT: ☐ START

BR 09-07-21 (X)

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

=> Sorlato



IDENTIFY & STOCK

50187 (X)

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/07/23 (X)

mf

09-07-23

Picklist Print

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Work Order ID: 50181

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base

Comments:

Start Date: 7/14/09

Required Date: 7/24/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2221-1RevH

Manufactured

No

100

Each

14.0000

1.0000



Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

14

48101

1

48318

5

48427

8

1 PD 09.07.15

D2221-5RevH

Manufactured

No

100

Each

4.0000

2.0000



Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4

48390

4

50026 → 2 100

Each

6.0000

1.0000

PD 09.07.15

D2221-7RevH

Manufactured

No



Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6

48201

2

48450

4

1 PD 09.07.15

Picklist Print

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Work Order ID: 50181

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base

Start Date: 7/14/09

Required Date: 7/24/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2232-3RevC

Manufactured

No

100

Each

15.0000

2.0000



Basket Hinge

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

15

47263

3

48443

12

2

PD 09-07-15

D2235-1RevB1

Manufactured

No

100

Each

17.0000

2.0000



Basket Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

17

48665

7

50029

10

2

PD 09-07-15

D2581RevA1

Manufactured

No

100

Each

35.0000

2.0000



Mounting Bracket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

35

46086

2

48428

33

2

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Shop Packet Print

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Picklist Print

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Page 3

Work Order ID: 50181

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base


Comments:

Start Date: 7/14/09

Required Date: 7/24/09


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3442-1RevA		Manufactured	No			100	Each	22.0000	2.0000			
												
Shim												


<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	22	
46767	1	
47074	9	
50023	12	

2 PD 09-07-16

D3825-041RevA		Manufactured	No			100	Each	8.0000	2.0000			
												
Rib Assembly (Basket End)												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	8	
48430	2	
48668	6	

2 PD 09-07-15

D3826-041RevB		Manufactured	No			100	Each	4.0000	2.0000			
												
Rib / Gusset Assembly												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	4	
48644	4	
50023	2	

PD 09-07-15

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Shop Packet Print

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Picklist Print

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Page 4

Work Order ID: 50181

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base

Comments:

Start Date: 7/14/09

Required Date: 7/24/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3827-041RevA

Manufactured

No

100

Each

7.0000

1.0000



Rib Assembly (Inboard)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

48100

1

48454

6

D3832-1RevA

Manufactured

No

100

Each

2.0000

1.0000



Mesh (Base)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

46306

1

46774

1

D3833-1RevA

Manufactured

No

100

Each

7.0000

2.0000



Mesh (Base End Face)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

46665

1

48646

6

PD 09.07.15

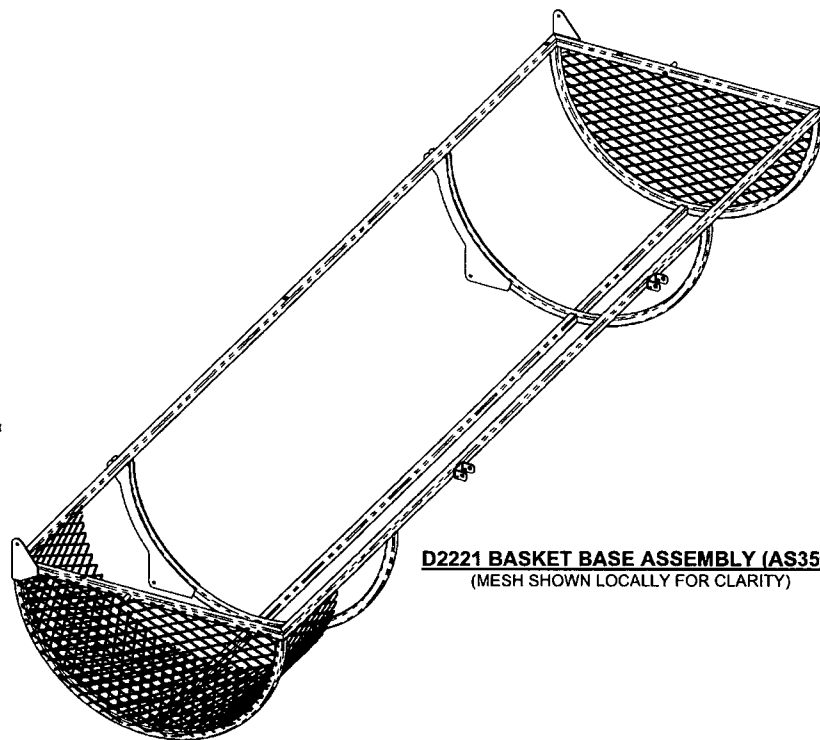
PD 09.07.16

2 PD 09.07.16

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Shop Packet Print

Page 4



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

W/O S&S

NOTES:

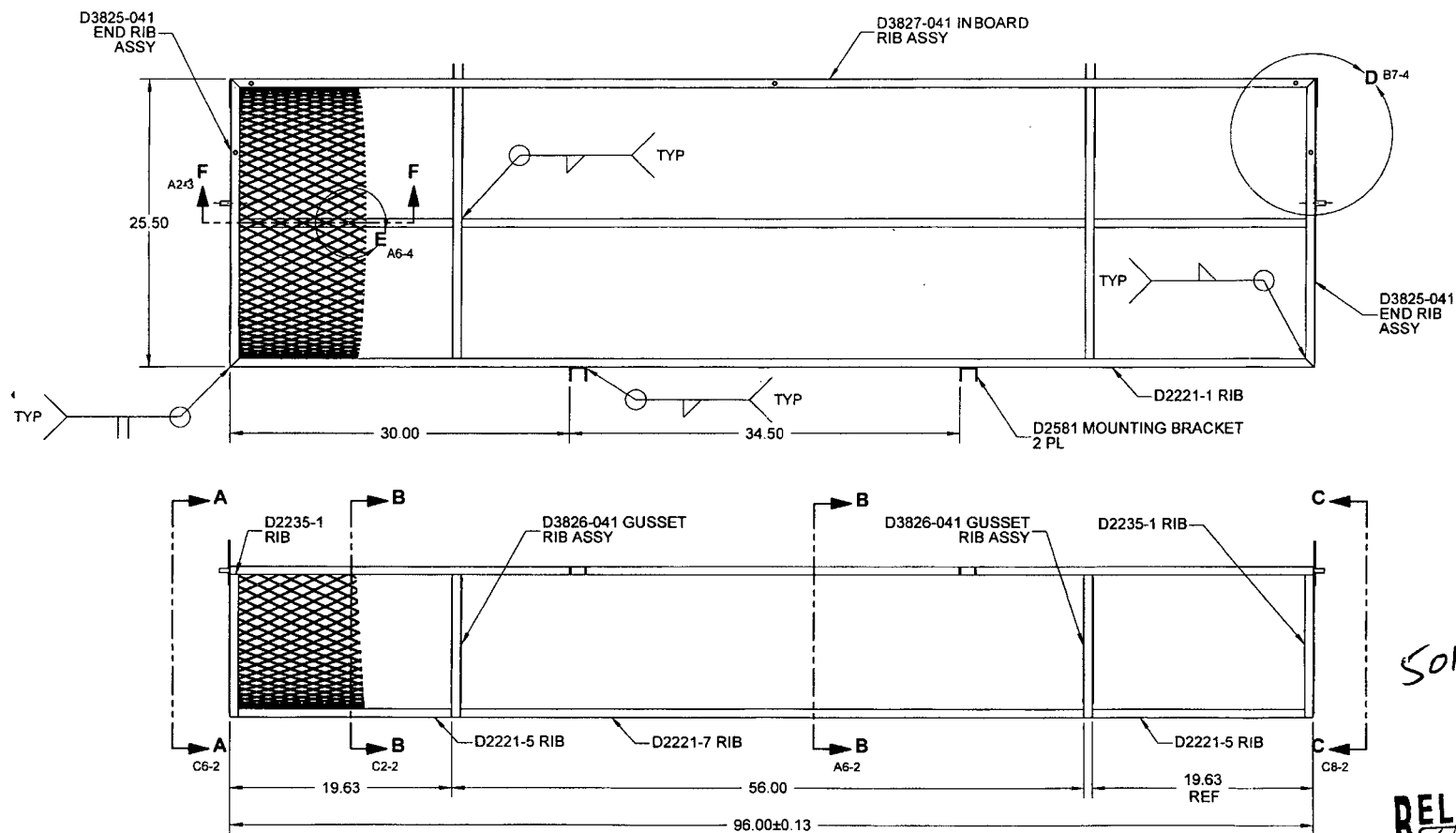
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING



ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

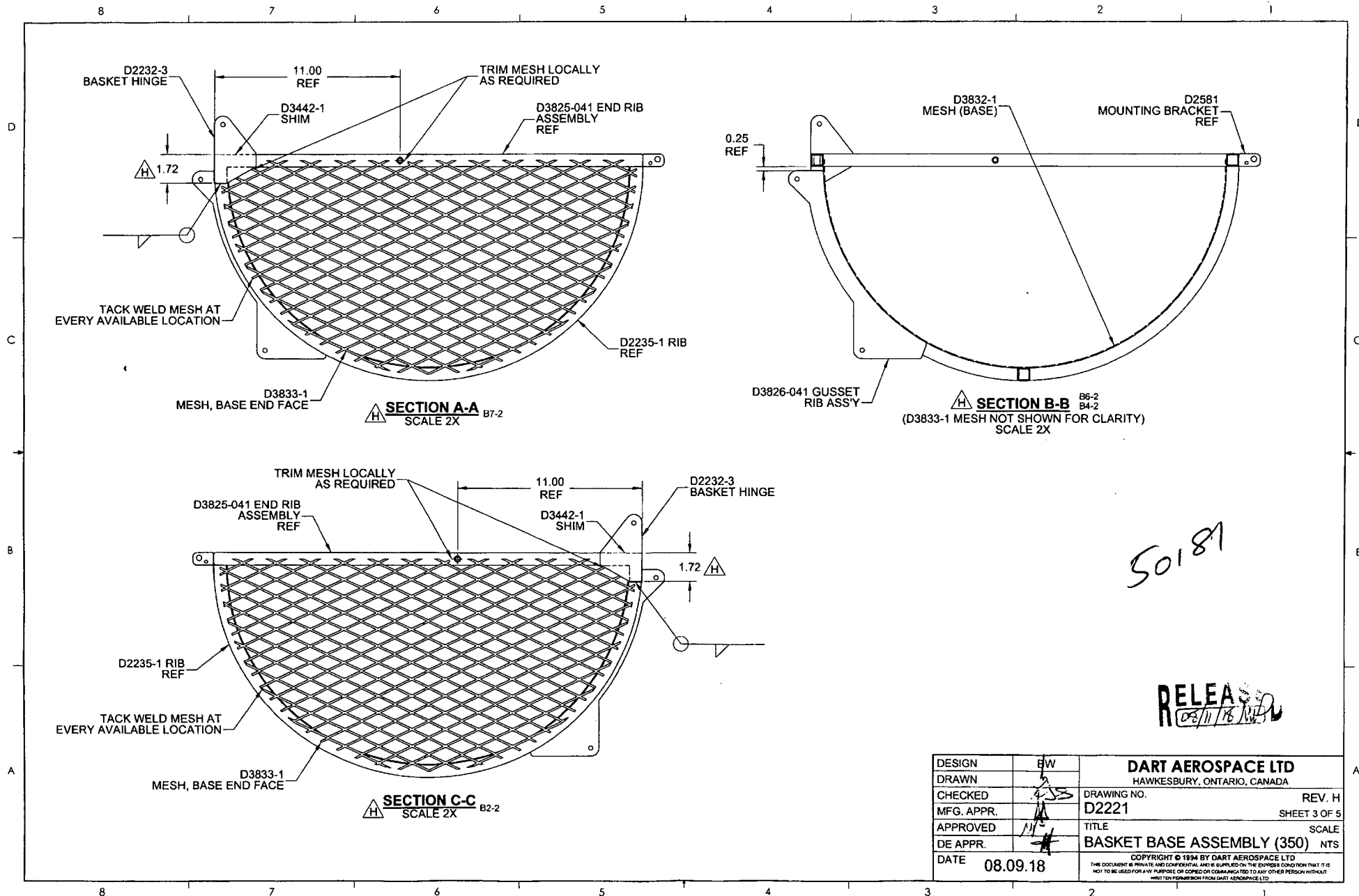
RELEASED
08/11/10

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
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08/11/18

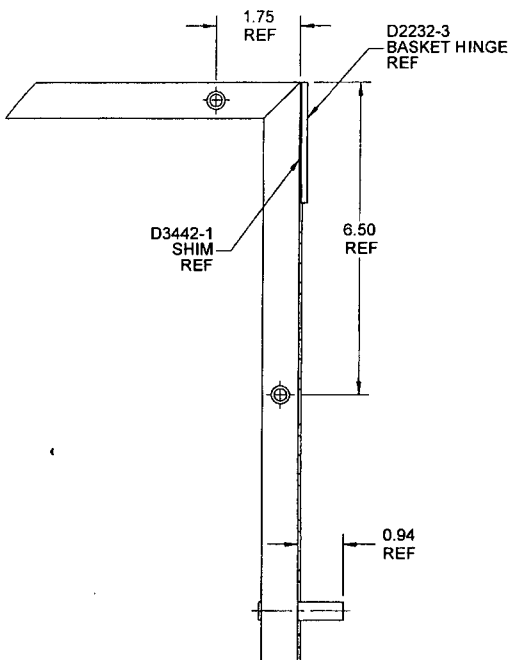
8 7 6 5 4 3 2 1

D

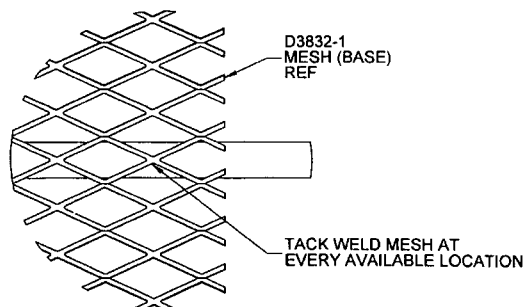
C

B

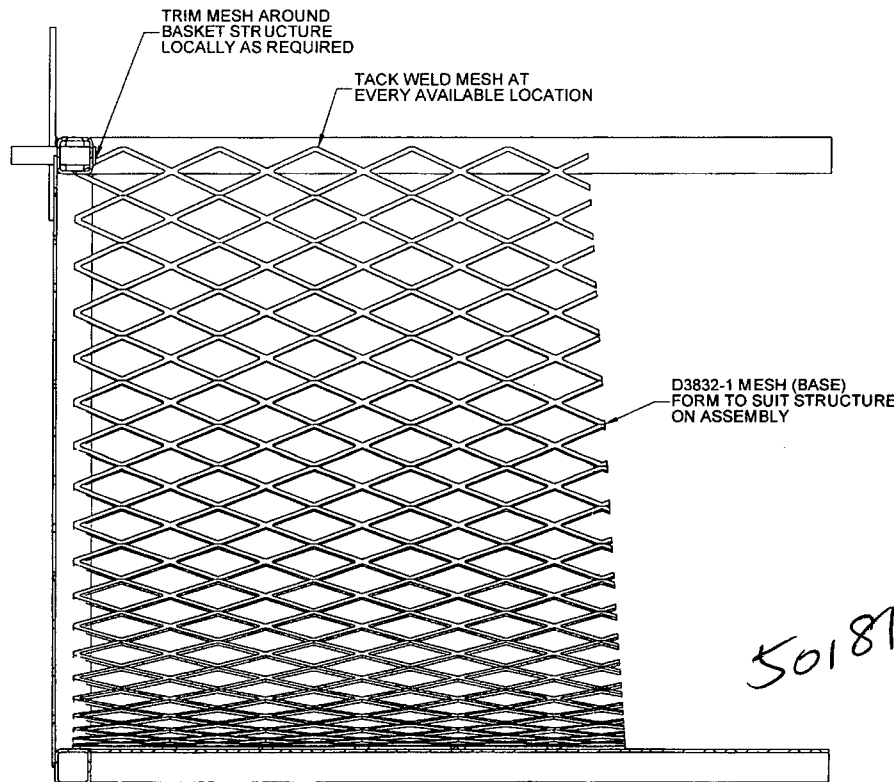
A



DETAIL D
SCALE 4X D2-2



DETAIL E
SCALE 4X C6-2

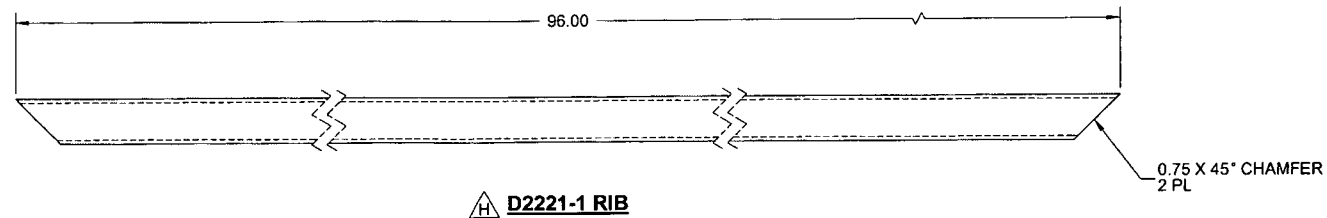
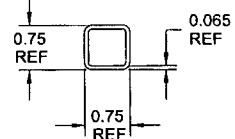
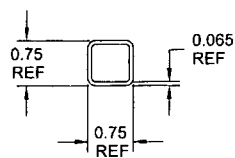


SECTION F-F
SCALE 4X D7-2

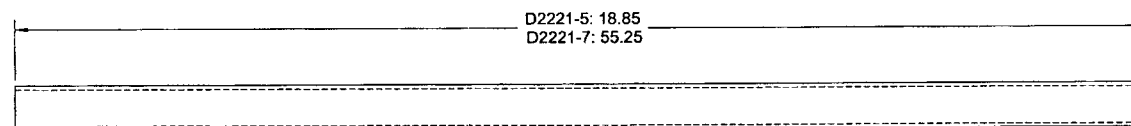
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08/11/18

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE ASSEMBLY (350) NTS	
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8 7 6 5 4 3 2 1



D2221-1 RIB



D2221-5/-7 RIB

50181

RELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2221	REV. H
MFG. APPR.		SHEET 5 OF 5	
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
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